

Date: Wednesday, 9/13/2006 4:17:26 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : REAR OVERHEAD PASSENGER MODIFICATION KIT
Job Number : 28505B
Estimate Number : 12509
P.O. Number : N/A
This Issue : 9/13/2006 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : SMALL / MED FAB
Previous Run : N/A
Written By :
Checked & Approved By :
Comment : est rev A 06.08.21 New Issue EC

Part Number : D206746043
Drawing Number : DSI9341 REVA.
Project Number : N/A
Drawing Revision : A
Material : N/A
Due Date : 10/10/2006 Qty: 1/2 Um: Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D3471041

BLOWER MOTOR SUPPORT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

BLOWER MOTOR SUPPORT

Batch: B 28541

MF 06-12-15

2.0

D3473041

BLOWER INLET ADAPTER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

BLOWER INLET ADAPTER

Batch: B 28543 B 28560

X

3.0

D3476041

blower motor adapter



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

blower motor adapter

Batch: B 28547

MF 06-12-15

4.0

D3477041

Blower Motor Inlet Adapter



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Blower Motor Inlet Adapter

Batch: B 28518

MF 06-12-15

5.0

26D71

Blower Motor



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

JANITROL BLOWER MOTOR ASSEMBLY

Batch: 412147 B 29839

MF 06-12-15

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services Drawing Name: REAR OVERHEAD PASSENGER MODIFICATION KIT

Job Number: 28505B

Part Number: D206746043

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

AN33A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total: 12.0000 Each(s)

Bolt

Batch: M 100651

MF. 06-12-15

7.0

AN96010

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total: 12.0000 Each(s)

Washer

Batch: M5519

MF. 06-12-15

MF. 06/10/17

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg DSI 9341

MF. 06-12-15
MF. 06/10/17 ①

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-10-17 ①

06-12-15 ①

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-746-043

Location:

PPP Rev:

06/12/05 ①

N/A 06/10/17 ①

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/12/15 ①

Job Completion



C 06/12/15

DART

| | | | |
|---------|----------|--|--------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. | REV. A |
| DATE | | DSI 9341 | SHEET 1 OF 2 |
| A | 06.08.09 | TITLE | SCALE |
| | | BLOWER MOTOR ASSEMBLY | 1:1 |
| | | NEW ISSUE | |

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-746 REV.A

REF. CANADIAN STC: SH05-45 ISSUE 1
FAA STC: SH3367NM DATED OCT. 13, 2005

The Parts List of Installation Instructions IIN-D206-746 Rev. A should be amended as follows:

| Qty -011 | Qty -041 | Qty -043 | Part Number | Description |
|----------|----------|----------|---------------|---|
| X | | | D206-746-011 | SHROUD AIRFLOW HEATER SYSTEM |
| 1 | X | | D206-746-041 | REAR OVERHEAD PASSENGER MODIFICATION KIT |
| 1 | | X | D206-746-043 | BLOWER MOTOR ASSEMBLY |
| | | 1 | D3471-041 | BLOWER MOTOR SUPPORT (CAM-1984-008) |
| | | 1 | D3473-041 | BLOWER INLET ADAPTER (CAM-1984-013) |
| | | 1 | D3476-041 | BLOWER MOTOR ADAPTER (CAM-1984-014) |
| | | 1 | D3477-041 | BLOWER MOTOR INLET ADAPTER (CAM-1984-015) |
| | | 1 | 26D71 | BLOWER MOTOR (26D71-1) |
| | | 6 | AN3-3A | BOLT |
| | | 6 | AN960-10 | WASHER |
| | | 3 | MS27039-08-04 | MACHINE SCREW |
| | | 3 | MS35333-38 | LOCK WASHER |

Furthermore, any mention of "Blower Motor Assembly" appearing in Installation Instructions IIN-D206-746 Rev. A, and Installation Drawing D206-746 Rev. A, should be replaced by D206-746-043 Blower Motor Assembly.

For assembly instructions of D206-746-043 Blower Motor Assembly, refer to page 2 of this DSI.

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WORK ORDER
NO. 28505B

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: D. SHEPHERD (DE # 02)

DATE: 06.08.09
CERT. NO.: SH05-45
ISSUE NO.: 1

NC

- 1) I
- 2) F
- 3) D

THIS DOC

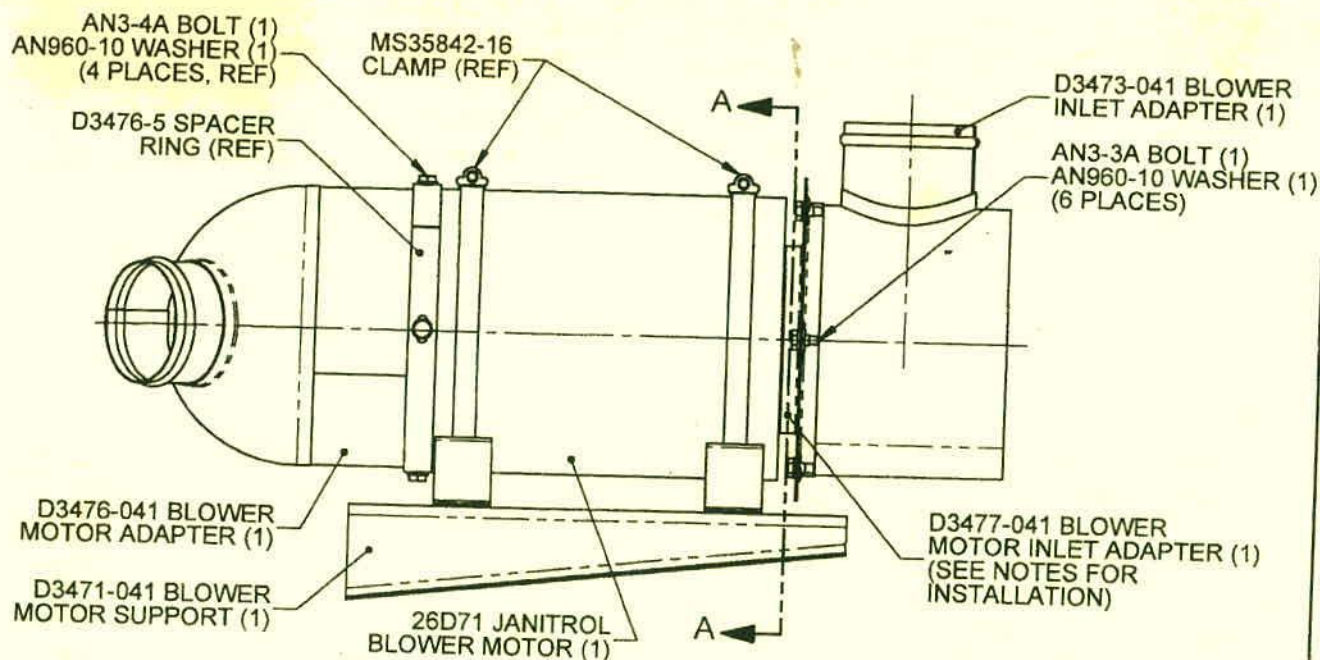
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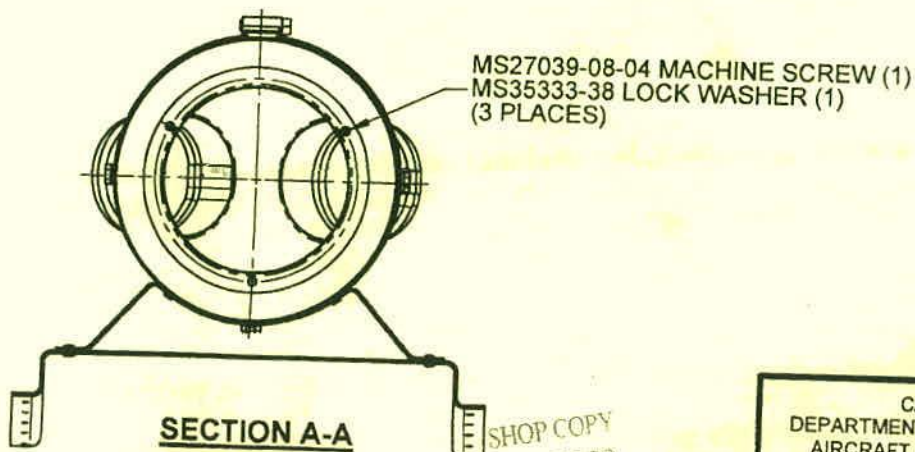
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DART

| | | | |
|-------------------------|---------------------------------------|--|------------------------------|
| DESIGN <i>B</i> | DRAWN BY <i>B</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>H</i> | APPROVED <i>H</i> | DRAWING NO. DSI 9341 | REV. A |
| DATE 06.08.09 | TITLE BLOWER MOTOR ASSEMBLY | | SHEET 2 OF 2 SCALE 1:4 |



D206-746-043 BLOWER MOTOR ASSEMBLY



NOTES:

- 1) ON 26D71 BLOWER MOTOR, REMOVE EXISTING MACHINE SCREWS (3), LOCK WASHERS (3) AND EXISTING ADAPTER (1).
- 2) REPLACE ADAPTER WITH D3477-041 BLOWER INLET ADAPTER. USE HARDWARE REMOVED AT STEP 1 TO SECURE D3473-041 BLOWER INLET ADAPTER TO 26D71 JANITROL BLOWER MOTOR.
- 3) D206-746-043 IS SUPPLIED TO CUSTOMER PRE-ASSEMBLED.

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WORK ORDER
NO. **28505B**

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

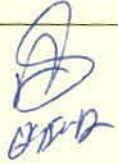
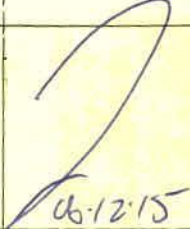


BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: **06.08.09**
CERT. NO.: **SH05-45**
ISSUE NO.: **1**

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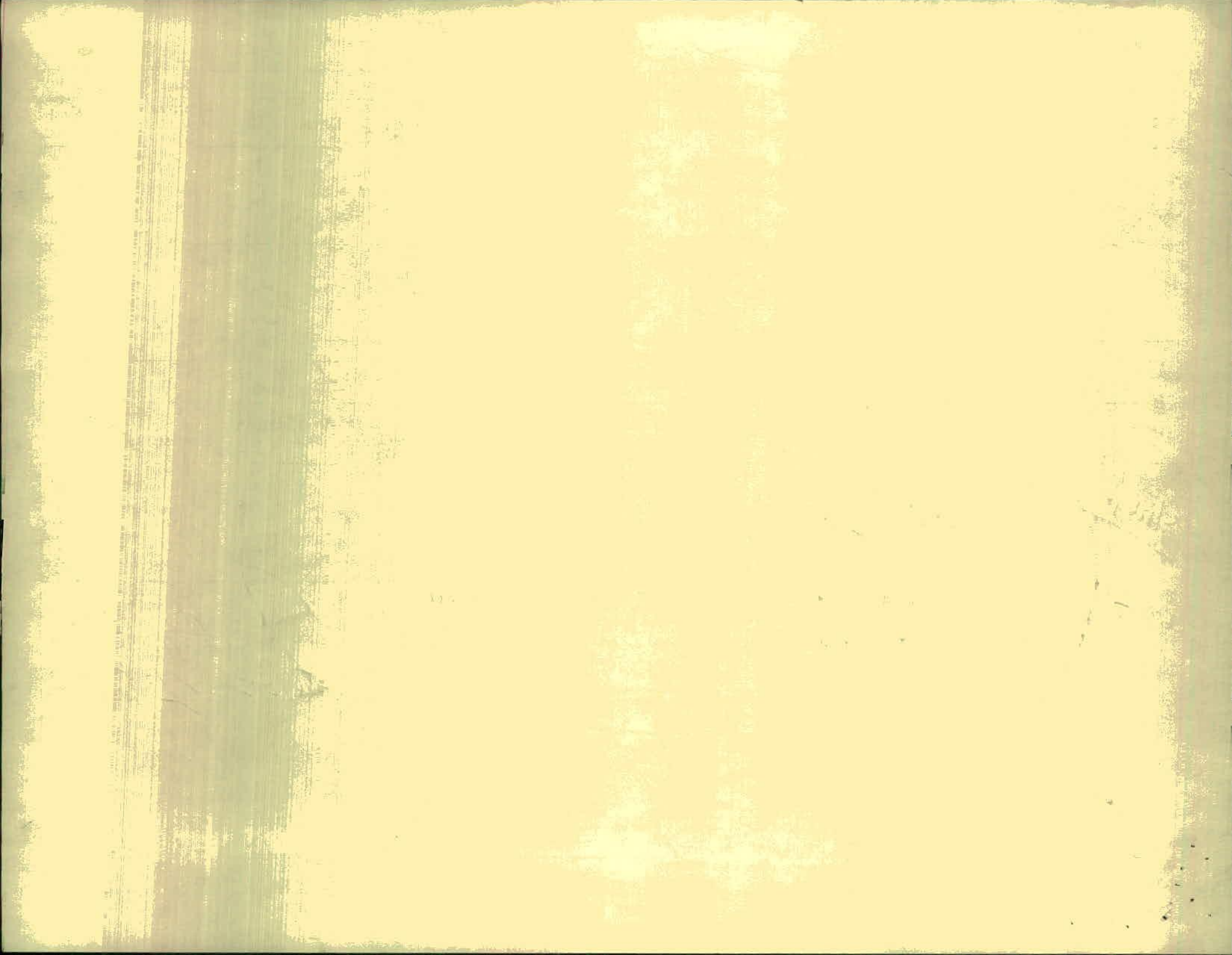
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---------------------|--------------|---|--|--|-----------------------|--|--|--|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| 06/12/14 | 8 | redrill hole to fit with motor hole | | | | | | |
| 06-12-15 | 8 | Holes in the 03477-041 did not align with the holes in 26D71 motor. |  | Drill holes in 03477-041 to align with motor for proper installation. This time only. | M.F. 06-12- 14. |  06-12-15 |  |  06-12-15 |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/12/15

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



Date: Wednesday, 9/13/2006 4:17:07 PM
 User: Kim Johnston

REFERENCE ONLY

Process Sheet

SLIP 1

| | | | |
|-----------------------|--|------------------|--|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : REAR OVERHEAD PASSENGER MODIFICATION KIT |
| Job Number | : 28505A | | |
| Estimate Number | : 12344 | | |
| P.O. Number | : | Part Number | : D206746041 |
| This Issue | : 9/13/2006 S.O. No. : | Drawing Number | : N/A |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : / / | Drawing Revision | : N/A |
| Previous Run | : 26901A | Material | : |
| | Type : SMALL /MED FAB | Due Date | : 10/10/2006 |
| Written By | : | Qty: | 2 Um: Each |
| Checked & Approved By | : | | |
| Comment | : est rev A 06.03.22 New Issue EC | | |
| | est rev B 06.04.26 Updated picklist EC | | |
| | Est Rev:C 06-05-24 As Per Rev A JLM | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|----|------------------|
| 1.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D206-746-041 CHG 001

| | | |
|-----|----------|-----------------------------|
| 2.0 | D3472041 | CABIN HEAT OUTLET DEFLECTOR |
|-----|----------|-----------------------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

| | | |
|-----|-------------|-------------------|
| Qty | Part Number | Description |
| 2 | D3472-041 | Cabin Heat outlet |

batch

1306172 x 4 dh

| | | |
|-----|--------|--------------|
| 3.0 | D34725 | FLAT DOUBLER |
|-----|--------|--------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

| | | |
|-----|-------------|--------------|
| Qty | Part Number | Description |
| 2 | D3472-5 | Flat doubler |

batch

1306128 dh ✓

| | | |
|-----|----------|---------------|
| 4.0 | D3479041 | INLET ADAPTER |
|-----|----------|---------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

| | | |
|-----|-------------|---------------|
| Qty | Part Number | Description |
| 2 | D3479-041 | Inlet adapter |

batch

1306172 x 4 dh

QB 06/10/13

REFERENCE ONLY

Wednesday, 9/13/2006 4:17:07 PM
Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REAR OVERHEAD PASSENGER MODIFICATION KIT

Job Number: 28505A

Part Number: D206746041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D3480041

Eyeball Inlet adapter



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description
2 D3480-041 eyeball inlet adapter

batch

B08528x2, *dh*

1 kit

6.0

D3480043

Eyeball adapter



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description
2 D3480-043 Eyeball adapter

batch

B28530 ✓ *dh*

7.0

D34807

Gasket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description
2 D3480-7 Gasket

batch

B26961 ✓ *dh*

8.0

99770094

FRESH AIR VENT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description
2 9977009-4 Bell eyeball

batch

M101045x1, M101045x1, M100158x2

1 kit

dh

9.0

AN34A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description
8 AN3-4A Bolt

batch

M18369 ✓ *dh*

LB ok 11/10/13

Wednesday, 9/13/2006 4:17:07 PM
Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REAR OVERHEAD PASSENGER MODIFICATION KIT

Job Number: 28505A

Part Number: D206746041

Job Number:



Seq. #:

Machine Or Operation:

Description:

10.0

AN96010L

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick:

Qty Part Number Description
16 AN960-10L Washer

batch

M101340 ✓ oh

11.0

CR224842

RIVET



Comment: Qty.: 24.0000 Each(s)/Unit Total: 48.0000 Each(s)

Pick:

Qty Part Number Description
24 CR2248-4-2 Rivet

batch

(M1524 x 10, M1969 2x8, M101334 x 30) 6x ok
oh oh

not in computer system
1 kit

12.0

HA000611

CARBON MONOXIDE INDICATOR



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

CARBON MONOXIDE INDICATOR

M101042 ✓ ok

13.0

MS27039110

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number Description
8 MS27039-1-10 Screw

batch

M18836 ✓ oh

14.0

NAS1738B42

Blind Rivet



Comment: Qty.: 12.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick:

Qty Part Number Description
12 NAS1738B4-2 Rivet

batch

M19347 ✓ d

AB06/10/04

8 NAS699A2

ABD10651 ✓ ok

4 x 52mm

M19356 oh

Pc 4/12/15 (U)

Date: Thursday, 23/11/2006 12:53:50 PM

User: Linda Lacelle

JOB HISTORY : DETAIL

| | | | |
|-------------------------|--------------|--------------------|--|
| Job Number | : 28505A | Customer | : Dart Helicopters Services |
| Estimate Number | : 12344 | DWG Name | : REAR OVERHEAD PASSENGER MODIFICATION KIT |
| Purchase Order # | : | Part Number | : D206746041 |
| Complete Date | : / / : : AM | DWG Number | : N/A |
| Rev. | : N/A | | |

| DUE DATE | ORDERED | DELIVERED |
|------------|---------|-----------|
| 10/10/2006 | 2 | 1 |

| 2.0 D3472041-CABIN HEAT OUTLET DEFLECTOR INVENTORY ITEM | | | | | |
|--|------------------------|----------|---------------|---------|--------------------|
| DATE | EMPLOYEE | TYPE | Qty | COST | |
| 04/10/2006 | BROS01: Brosseau, Lynn | D3472041 | 4.000 | \$35.57 | Lot # 26172 Qty. 4 |
| Subtotal: | | | QTD: 0 CTD: 4 | \$35.57 | |

| 3.0 D34725-FLAT DOUBLER INVENTORY ITEM | | | | | |
|---|------------------------|--------|---------------|---------|--------------------|
| DATE | EMPLOYEE | TYPE | Qty | COST | |
| 04/10/2006 | BROS01: Brosseau, Lynn | D34725 | 4.000 | \$22.68 | Lot # 26128 Qty. 4 |
| Subtotal: | | | QTD: 0 CTD: 4 | \$22.68 | |

| 4.0 D3479041-INLET ADAPTER INVENTORY ITEM | | | | | |
|--|------------------------|----------|---------------|----------|--------------------|
| DATE | EMPLOYEE | TYPE | Qty | COST | |
| 13/10/2006 | BROS01: Brosseau, Lynn | D3479041 | 4.000 | \$681.43 | Lot # 28526 Qty. 4 |
| Subtotal: | | | QTD: 0 CTD: 4 | \$681.43 | |

| 5.0 D3480041-Eyeball Inlet adapter INVENTORY ITEM | | | | | |
|--|------------------------|----------|---------------|----------|--------------------|
| DATE | EMPLOYEE | TYPE | Qty | COST | |
| 13/10/2006 | BROS01: Brosseau, Lynn | D3480041 | 2.000 | \$176.06 | Lot # 28528 Qty. 2 |
| Subtotal: | | | QTD: 0 CTD: 2 | \$176.06 | |

| 6.0 D3480043-Eyeball adapter INVENTORY ITEM | | | | | |
|--|------------------------|----------|---------------|---------|--------------------|
| DATE | EMPLOYEE | TYPE | Qty | COST | |
| 04/10/2006 | BROS01: Brosseau, Lynn | D3480043 | 4.000 | \$83.43 | Lot # 28530 Qty. 4 |
| Subtotal: | | | QTD: 0 CTD: 4 | \$83.43 | |

| 7.0 D34807-Gasket INVENTORY ITEM | | | | | |
|---|------------------------|--------|---------------|---------|--------------------|
| DATE | EMPLOYEE | TYPE | Qty | COST | |
| 04/10/2006 | BROS01: Brosseau, Lynn | D34807 | 4.000 | \$26.03 | Lot # 26961 Qty. 4 |
| Subtotal: | | | QTD: 0 CTD: 4 | \$26.03 | |

| 8.0 99770094-FRESH AIR VENT INVENTORY ITEM | | | | | |
|---|------------------------|----------|---------------|----------|---------------------|
| DATE | EMPLOYEE | TYPE | Qty | COST | |
| 04/10/2006 | BROS01: Brosseau, Lynn | 99770094 | 2.000 | \$208.72 | Lot # 101045 Qty. 2 |
| 04/10/2006 | BROS01: Brosseau, Lynn | 99770094 | 2.000 | \$208.72 | Lot # 100158 Qty. 2 |
| Subtotal: | | | QTD: 0 CTD: 4 | \$417.44 | |

| 9.0 AN34A-Bolt INVENTORY ITEM | | | | | |
|--------------------------------------|------------------------|-------|----------------|--------|---------------------|
| DATE | EMPLOYEE | TYPE | Qty | COST | |
| 04/10/2006 | BROS01: Brosseau, Lynn | AN34A | 16.000 | \$1.22 | Lot # 18369 Qty. 16 |
| Subtotal: | | | QTD: 0 CTD: 16 | \$1.22 | |

Date: Thursday, 23/11/2006 12:53:50 PM

User: Linda Lacelle

JOB HISTORY : DETAIL

| | | | |
|-------------------------|--------------|--------------------|--|
| Job Number | : 28505A | Customer | : Dart Helicopters Services |
| Estimate Number | : 12344 | DWG Name | : REAR OVERHEAD PASSENGER MODIFICATION KIT |
| Purchase Order # | : | Part Number | : D206746041 |
| Complete Date | : / / : : AM | DWG Number | : N/A |
| | | Rev. | : N/A |

10.0 AN96010L-Washer INVENTORY ITEM

| DATE | EMPLOYEE | TYPE | Qty | COST | |
|------------------|------------------------|----------|----------------|--------|----------------------|
| 04/10/2006 | BROS01: Brosseau, Lynn | AN96010L | 32.000 | \$0.45 | Lot # 101340 Qty. 32 |
| Subtotal: | | | QTD: 0 CTD: 32 | \$0.45 | |

11.0 CR224842-RIVET INVENTORY ITEM

| DATE | EMPLOYEE | TYPE | Qty | COST | |
|------------------|------------------------|----------|----------------|---------|----------------------|
| 04/10/2006 | BROS01: Brosseau, Lynn | CR224842 | 30.000 | \$14.94 | Lot # 101334 Qty. 30 |
| 17/10/2006 | LACE01: Lacelle, Linda | CR224842 | 18.000 | \$8.96 | Lot # 101334 Qty. 18 |
| Subtotal: | | | QTD: 0 CTD: 48 | \$23.90 | |

12.0 HA000611-CARBON MONOXIDE INDICATOR INVENTORY ITEM

| DATE | EMPLOYEE | TYPE | Qty | COST | |
|------------------|------------------------|----------|---------------|---------|---------------------|
| 04/10/2006 | BROS01: Brosseau, Lynn | HA000611 | 2.000 | \$12.18 | Lot # 101042 Qty. 2 |
| Subtotal: | | | QTD: 0 CTD: 2 | \$12.18 | |

13.0 MS27039110-Screw INVENTORY ITEM

| DATE | EMPLOYEE | TYPE | Qty | COST | |
|------------------|------------------------|------------|----------------|--------|---------------------|
| 04/10/2006 | BROS01: Brosseau, Lynn | MS27039110 | 16.000 | \$1.29 | Lot # 18836 Qty. 16 |
| Subtotal: | | | QTD: 0 CTD: 16 | \$1.29 | |

14.0 NAS1738B42-Blind Rivet INVENTORY ITEM

| DATE | EMPLOYEE | TYPE | Qty | COST | |
|------------------|------------------------|---------------|----------------|---------|---------------------|
| 04/10/2006 | BROS01: Brosseau, Lynn | NAS1738B42 ok | 24.000 | \$11.11 | Lot # 19347 Qty. 24 |
| Subtotal: | | | QTD: 0 CTD: 24 | \$11.11 | |

15.0 NAS679A3-NUT SELF LOCK INVENTORY ITEM

| DATE | EMPLOYEE | TYPE | Qty | COST | |
|------------------|------------------------|-------------|----------------|--------|----------------------|
| 04/10/2006 | BROS01: Brosseau, Lynn | NAS679A3 18 | 16.000 | \$6.03 | Lot # 100651 Qty. 16 |
| Subtotal: | | | QTD: 0 CTD: 16 | \$6.03 | |

17.0 QC4 Internal Operation

| DATE | EMPLOYEE | TYPE | Qty | Time(hrs) | COST | MTime(hrs) | Mach.Cost |
|------------------|--------------------------|------|---------------|-----------|---------|------------|-----------|
| 17/10/2006 | DESJ02: Desjardins, Line | Run | 1.000 | 0.16 | \$2.20 | 0.30 | 7.80 |
| Subtotal: | | | QTD: 1 CTD: 0 | 0.16 | \$10.00 | | |

18.0 PACKAGING 1 Internal Operation

| DATE | EMPLOYEE | TYPE | Qty | Time(hrs) | COST | MTime(hrs) | Mach.Cost |
|------------------|--------------------------|------|---------------|-----------|---------|------------|-----------|
| 04/10/2006 | BROS01: Brosseau, Lynn | Run | 2.000 | 0.88 | \$11.44 | 1.75 | 35.00 |
| 13/10/2006 | BROS01: Brosseau, Lynn | Run | 1.000 | 0.20 | \$2.60 | 0.20 | 4.00 |
| 17/10/2006 | DESJ02: Desjardins, Line | Run | 1.000 | 0.13 | \$1.79 | 0.25 | 5.00 |
| Subtotal: | | | QTD: 4 CTD: 0 | 1.21 | \$59.83 | | |

| | | TIME | COST | |
|----------------|------------------------------|------|-----------|--|
| | Machine Time: | 2.50 | \$51.80 | |
| | Labor: | 1.37 | \$18.03 | |
| | Sub-contract (external Op.): | | \$0.00 | |
| | INVENTORY ITEM: | | \$1498.82 | |
| | SUB-COMPONENT (SUB-JOB): | | \$0.00 | |
| Total: | | | \$1568.65 | |
| COST PER UNIT: | | | \$1568.65 | |

12061215

